

Work Order ID 79252

79252

Page 1

January-24-12 10:58:39 AM

Item ID: D206-642-151

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 24/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 15/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.C.J.

Date: 12/01/25 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

100

0.00

100

DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

[Handwritten signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804								
	3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.								
	Pick:								
	Qty Part Number DescriptionBatch								
	A/R Aluminum Rod <u>M120164</u>								
	4-Grind weld flush to cap on top surface only.								
	5-Cut Aft end as per dwg D3804 from front of tube and Deburr								
	6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804								
	7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.								
	8-Drill pilot holes using Dt8166 & DT8169D & DT9771.								
	9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.								
	10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.								

1 0 ~~12-2-23~~

BB 12/02/23

ac 12/03/01

SAD 12-03-01

SAD 12-03-01

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

Sizer log

SAD 12-03-61

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				12/03/02			
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							① SAN 12-03-02
160 *160* Skidtubes Skidtubes	Skidtubes Memo 1-Open holes to finished size as per Dwg D3804, (without cutting fluid) 2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid) 3-Deburr and blow out all chips from inside the tube	0.00 0.00							De 12/03/02

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170 QC6- Inspect dimensions to drawing 0.00

170

QC

Memo

0.00

Quality Control

1 0 BE 12/03/02

180

0.00

180

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12

Hrs. cure time before cutting

Start Date: 12/03/02 Time: 10:38

Finish Date: 12/03/02 Time: 8:00

Pick:

Qty Part Number Description Batch

A/RSikaflex-291 119 999

Sikaflex expire date: 12/08/13

pe 12/03/02

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1

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1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

1 0 BE 12/03/04

W/O:		WORK ORDER CHANGES					
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch

A/RAluminum Rod 7130104

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

BE 12/03/04

12/03/06

BE 12/03/05

DP 12-3-5

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 Required Date: 15/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	HandFinishing	0.00							
210	HandFinish	0.00							
Hand Finishing	Memo								
	Install D2680-041 Nut Plate as per Dwg D3804								
215	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
215	QC	0.00							
Quality Control	Memo								
220	QC10- Inspect visual per QSI004- ground welds	0.00							
220	QC	0.00							
Quality Control	Memo								

Handwritten: 12/03/05

Handwritten: 12.03.05

Handwritten: 1x

Handwritten: 12.03.05

Handwritten: 1x

W/O:		WORK ORDER CHANGES					
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1

Cust Item ID:

Required Date: 15/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230 QC5- Inspect part completeness to step on W/O

0.00

230

QC

Memo

0.00

Quality Control

240 Pressure Wash per QSI005 4.3

0.00

240

HandFinish

Memo

0.00

Hand Finishing

250 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

250

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:45
320 °F
4:15

1X Q M/F 12/03/06

1X Q M/F 12/03/07

M120222

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
260									
QC	Memo	0.00							
Quality Control									
270	HandFinishing	0.00							
270									
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								

W/O:		WORK ORDER CHANGES					
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280

0.00

280

HandFinishing

0.00

HandFinish

Memo

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

✓ A/RSikaflex-291 11119999

Sikaflex expire date: 12/08

✓ 2- Install wearplate as per dwg

✓ 2-Wing Walk as per Dwg D3804 and QSI 005 4.4

Batch: 111012

1 h 11 of 221 12/03/08

290

QC3- Inspect Part Finish

0.00

290

QC

Memo

Quality Control

0.00

510 103/09

W/O:		WORK ORDER CHANGES					
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300

QC5- Inspect part completeness to step on W/O

0.00

300

QC

Memo

0.00

Quality Control

310

Packaging

0.00

310

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-151

Location: _____

PPP Rev: _____

320

QC21- Final Inspection - Work Order Release

0.00

320

QC

Memo

0.00

Quality Control

79436 12/3/12

12/3/12

MF 12-03-12

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Picklist Print

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Work Order ID: 79252

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Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 15/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV:N DD VERF:EC IPP
REV:B 11.09.16 PER IIN REV:O DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620		Manufactured	No			110	Each	8.0000	1	1			
D2620									**	1		BB 12/02/23	
Skidtube, 206 Skidtube													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				8					
				71617				2					
				77997				6					
D2647		Manufactured	No			110	Each	133.0000	1	1			
D2647									**			BB 12/02/23	
Cap													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG002				133					
				73826				24					
				75482				109					
CR3212-4-04		Purchased	No			180	Each	10,198.00	52	52			
CR3212-4-04									**			DC 12/03/02	
Cherry Rivet													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST331				364					
				116471				78					
				117816				3					
				118686				1					
				118840				16					
				119017				256					
				119075				10					
				st510				9834					
				119075				9834				52	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-24-12 10:58:43 AM

Work Order ID: 79252

79252

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 15/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2654-1

Manufactured No

180

Each

25.0000

1

1

D2654-1

Web

**

De 12/03/02

Location

79541

Loc Qty

Loc Code

(1)

LG

25

77278

2

77279

10

77280

3

77281

10

D3286-1

Manufactured No

180

Each

231.0000

2

2

D3286-1

Doubler

**

SAD 12-03-01

Location

Loc Qty

Loc Code

LG002

233

74872

6

78014

109

ST046

-2

76772

116

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-24-12 10:58:43 AM

Work Order ID: 79252

79252

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 15/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

200

Each

559.0000

19

19

D2649

Cross Bolt Spacer

BE 12/03/04
*B 79504 *19*

Location

Loc Qty

Loc Code

LG

40

77574

40

LG001

519

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

400

D3286-3

Manufactured No

200

Each

128.0000

2

2

D3286-3

Spacer

BE 12/03/05
*B 79557 *2*

Location

Loc Qty

Loc Code

LG

100

78015

100

LG001

28

74117

1

76773

27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-24-12 10:58:43 AM

Work Order ID: 79252

79252

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 15/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041 Manufactured No

210 Each 110.0000 1 1

D2680-041

Nut Plate

**

① JB 12/03/06

Location

Loc Qty

Loc Code

ST013

14

75479

14

ST019

96

76790

96

CR3212-4-03 Purchased No

210 Each 1,650.000 2 2

CR3212-4-03

Cherry Rivet

**

② JB 12/03/06

Location

Loc Qty

Loc Code

FP002

660

114859

660

ST331

990

110139

2

119017

988

AN960JD416 NAS1149D0463J Purchased No

210 Each 0.0000 1 1

AN960JD416

Washer

**

M118384 (x1) JV 12/03/06

CCR264SS3-3 Purchased No

210 Each 885.0000 2 2

CCR264SS3-3

Cherry Rivet

**

② JB 12/03/06

Location

Loc Qty

Loc Code

ST331

885

113973

2

117849

135

119017

748

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-24-12 10:58:43 AM

Work Order ID: 79252

79252

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 15/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

277.0000

1

1

MS27039-4-06

Screw

**

YH 12/03/08

Location

Loc Qty

Loc Code

ST292

277

119075

277

xl

D2651-1

Manufactured

No

270

Each

527.0000

6

6

D2651-1

Plug

**

YH 12/03/08

Location

Loc Qty

Loc Code

FP001

413

57869

1

66445

10

69018

2

70827

2

70839

8

70942

14

71037

53

73827

23

FP-A

114

77559

114

78124

300

x6

D2651-3

Manufactured

No

270

Each

2,547.000

6

6

D2651-3

O-Ring

**

YH 12/03/08

Location

Loc Qty

Loc Code

FP001

547

61962

12

73828

535

x6

FP-A

2000

78126

2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 6

January-24-12 10:58:43 AM

Work Order ID: 79252

79252

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 15/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3873-1 Manufactured No

280 Each 509.0000 14 14

D3873-1

Bushing

**

B79561 (x14) MU 12/03/08

Location

Loc Qty

Loc Code

ST067

509

64760

1

68247

4

73829

19

73830

2

78017

483

D2646 Manufactured No

280 Each 96.0000 1 1

D2646

Aft Cap

**

B78018 (x1) MU 12/03/08

Location

Loc Qty

Loc Code

FP002

96

62678

5

68280

5

70945

1

71038

4

71070

2

73294

1

73825

78

D3805-041 Manufactured No

280 Each 0.0000 1 1

D3805-041

Wearplate Assembly Fwd, Low Gear

**

B78003 (x1) MU 12/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

January-24-12 10:58:43 AM

Work Order ID: 79252

79252

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 15/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,907.000

2

2

MS27039-1-08

Screw

**

11 12/03/08

Location

Loc Qty

Loc Code

ST291

1907

117423

77

118910

2

119075

328

119109

500

120308

1000

x2

MS21042L3

Purchased

No

280

Each

5,641.000

7

7

MS21042L3

Nut

**

11 12/03/08

Location

Loc Qty

Loc Code

ST300

5641

117441

16

117885

32

118451

5

118927

3

119017

5120

119075

465

x7

D3805-045

Manufactured

No

280

Each

7.0000

1

1

D3805-045

Wearplate Assembly Aft, Low Gear

**

1378011(1) 11 12/03/08

Location

Loc Qty

Loc Code

FP001

7

73817

1

74896

1

76786

5

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2

***AN960JD10L ***

Washer

**

11120644(x2) 11 12/03/08

January-24-12 10:58:43 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-24-12 10:58:43 AM

Work Order ID: 79252

79252

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 15/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-37A Purchased No

280 Each 1,231.000 7 7

AN3-37A

Bolt

HL 12/03/08

Location

Loc Qty

Loc Code

ST353

1231

117619

4

119086

1227

X-7

NAS1149D0363J Purchased No

280 Each 3,670.000 7 7

NAS1149D0363.J

Washer

HL 12/03/08

Location

Loc Qty

Loc Code

ST298

3670

117601

61

118077

1

118612

18

119537

1041

120142

1549

120308

1000

X-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

UNCLAS
SUBS
NO. 79252 M.L.J
12/01/25

RELEASED
09.03.03
per ECN 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.07		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3804
REV. A
SHEET 1 OF 5

TITLE SKIDTUBE ASSEMBLY, 206A/B
SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

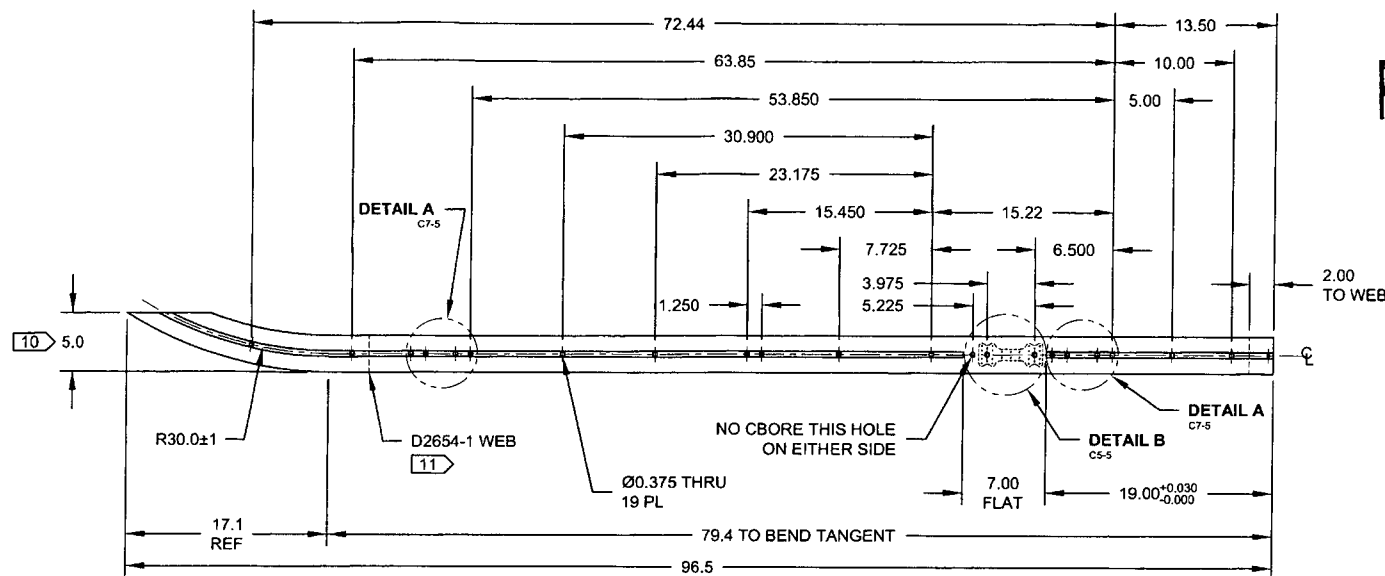
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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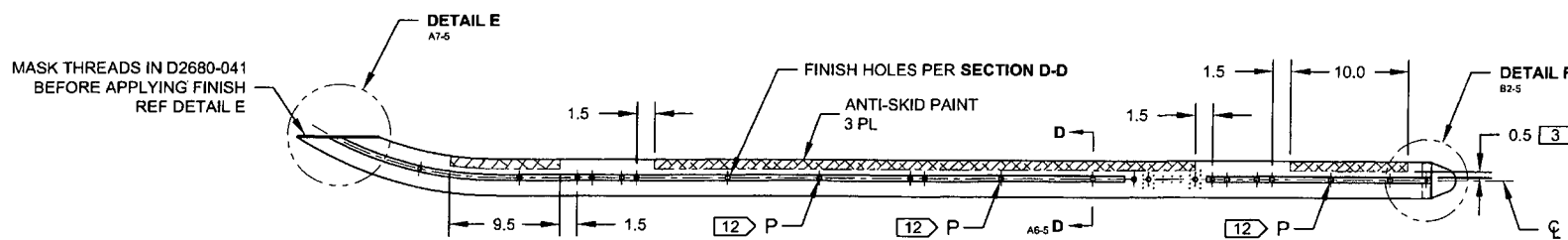
NOTE: Date & initial all entries

79252

RELEASED
09.13.07



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	BE	D3804	SHEET 2 OF 5
APPROVED	169	TITLE	SCALE
DE APPR.	169	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
APR 09 03 03



DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	P	DRAWING NO.	REV. A
MFG. APPR.	E	D3804	SHEET 3 OF 5
APPROVED	AP	TITLE	SCALE
DE APPR.	HA	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

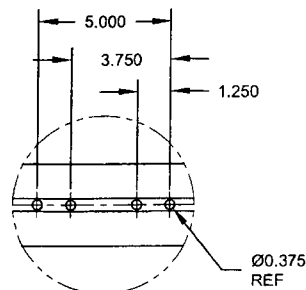
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

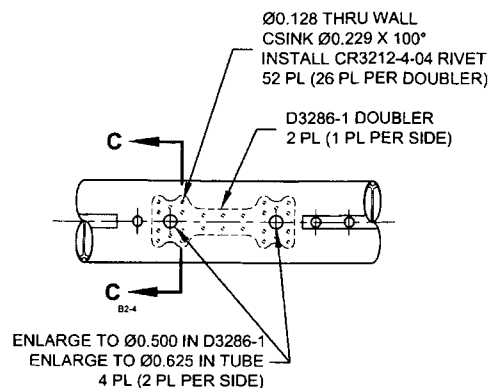
NOTE: Date & initial all entries

79252

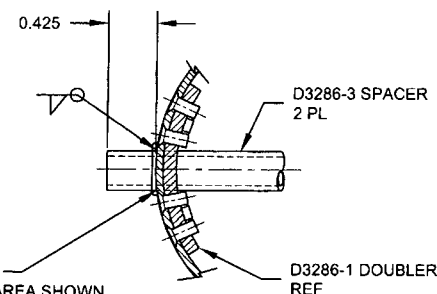
RELEASED
CP 09.03.03



DETAIL A
D6-2
C2-2
D6-3
C2-3
SCALE NONE

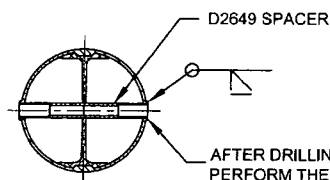


DETAIL B
C3-2
C3-3
SCALE NONE



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D A4-2
A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	1	PORT HADLOCK, WA	
CHECKED	1	DRAWING NO.	REV. A
MFG. APPR.	1	D3804	SHEET 4 OF 5
APPROVED	1	TITLE	SCALE
DE APPR.	1	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

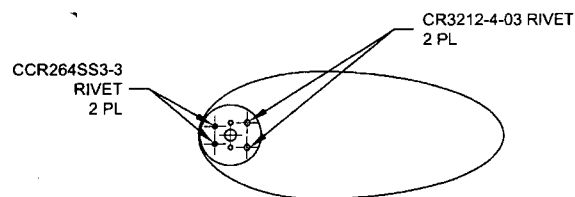
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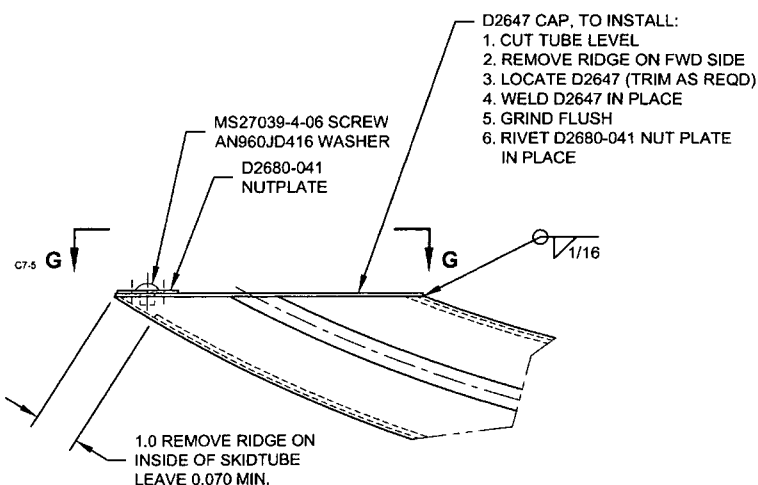
NOTE: Date & initial all entries

79252

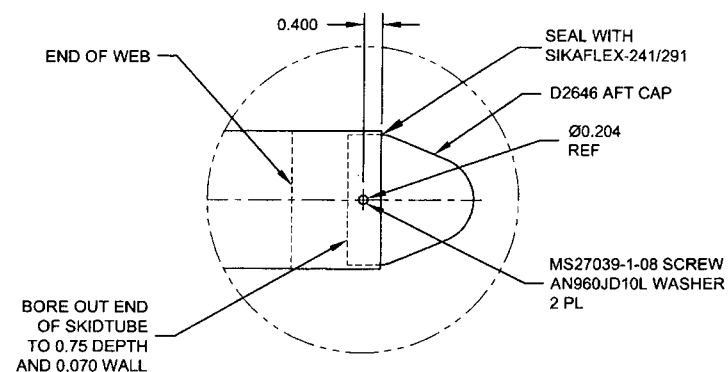
RELEASED
QD 09.03.04



VIEW G-G
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2 B7-3



DETAIL F
SCALE NONE B2-2 B2-3

DESIGN	QD	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	Q	DRAWING NO.	REV. A
MFG. APPR.	E	D3804	SHEET 5 OF 5
APPROVED	QD	TITLE	SCALE
DE APPR.	J	SKIDTUBE ASSEMBLY, 206A/B	NTS
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 283

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 79243
Part number: A206-642-151
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum.
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Nival Date of Test Coupon 12.02.22

Welder Barclay Elliott Date of Test Coupon 12.02.22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld